

Date: Friday, 7/4/2008 8:47:05 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	BRACKET		
Job Number	40255			Part Number	D32641		
Estimate Number	11162			Drawing Number	D3264 REV A		
P.O. Number				Project Number	N/A		
This Issue	7/4/2008	S.O. No.		Drawing Revision	A		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	MACHINED PARTS	Due Date	7/22/2008	Qty:	5
Previous Run	37370			Um:	Each		
Written By	<i>JK</i> 08 07 04						
Checked & Approved By							
Comment	Est	A	04.09.02	New issue	KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B1250X04500	6061-T6 Bar 1.25" X 4.5"	
		Comment: Qty.: 0.5097 f(s)/Unit. Total : 3.0580 f(s) Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B1.250x04.500) Identify for D3264-1 Batch: M105531	H.A 08/07/05
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 4.500" x 1.250" x 5.700" long Bar	H.A 08/07/05
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	(P10)
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA447 and Dwg D3264 Identify as D3264-1 Deburr	H.A/mk 08/07/05
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	H.A/mk 08/07/05
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	JK 08/07/05 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D32464-1 PAR #: N/A Fault Category: Prod / Mach. Red parts NCR: Yes No DQA: D Date: 08/07/11
 QA: N/C Closed: D Date: 08/07/11

NCR: 40255		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.07.07	3	Tool mark on inner surface Re. Tool fall pulled out of holder operator error holder not tight enough.	CP 08.07.07 PV QSI 04/2	SCRAP no mat. to do a replacement. Qty <u>4</u>	M.A 08/07/07	S 08/07/10	GP 08.07.07 PV QSI 04/2	G 08/07/10

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF/BK 08-07-08

7.0 POWDER COATING

POWDER COATING



M107925

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:15pm

OVEN TEMPERATURE:

320° F

FINISH TIME:

1:45pm

11 08-07-08

X5

5

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 08/07/08

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 5164

(5)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/10 MF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40255
Description: Bracket	Part Number:	D3264-1
Inspection Dwg: D3264 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

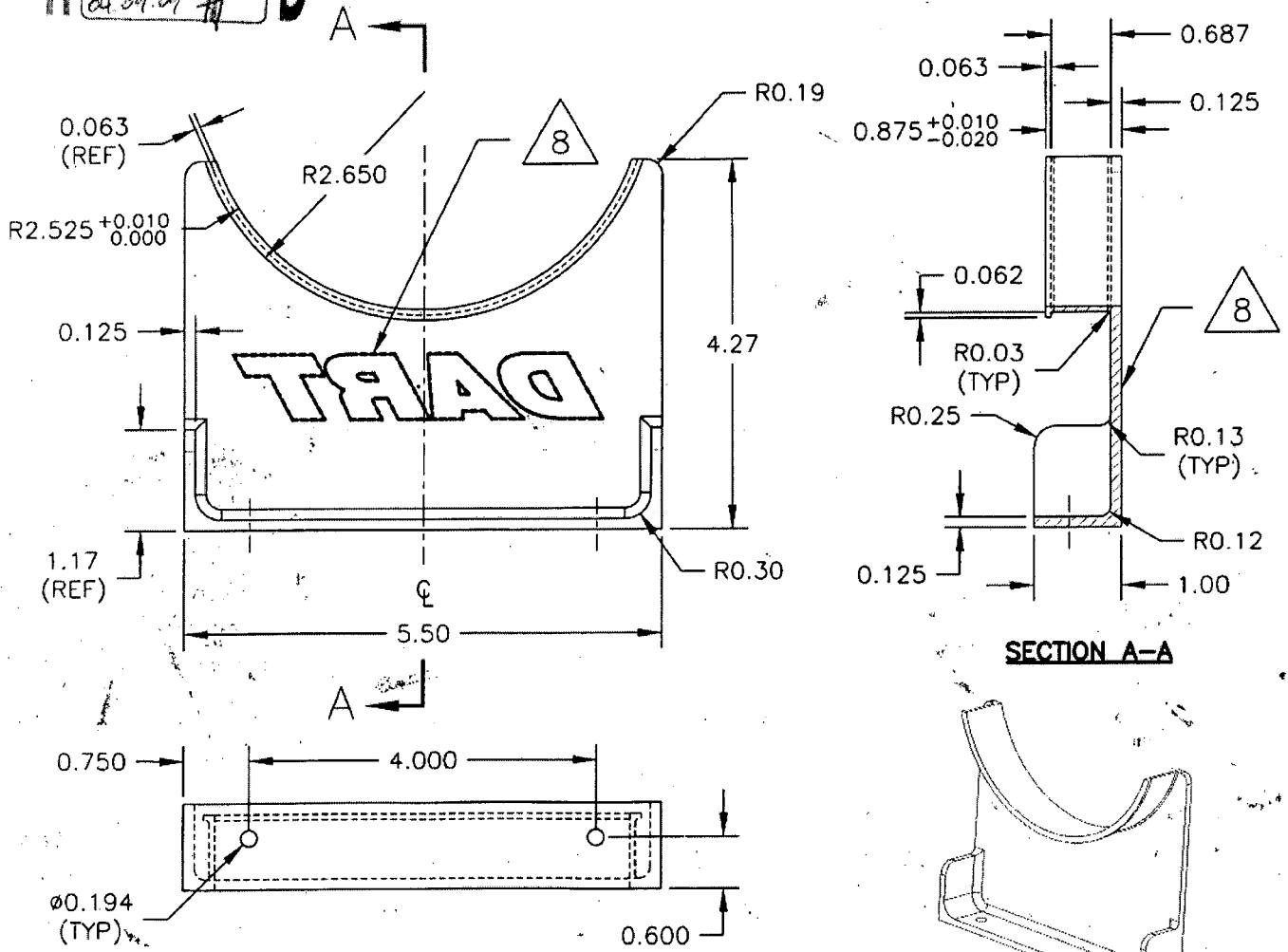
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.690	✓			
0.063	+/-0.010	0.061	✓			
0.125	+/-0.010	0.125	✓			
0.875	+0.010/-0.020	0.877	✓			
0.062	+/-0.010	0.064	✓			
R0.03	+/-0.030	R 0.03	✓			
R0.13	+/-0.030	R 0.130	✓			
1.00	+/-0.030	1.004	✓			
0.125	+/-0.010	0.125	✓			
0.600	+/-0.010	0.599	✓			
4.000	+/-0.005	4.000	✓			
0.750	+/-0.010	0.750	✓			
Ø0.194	+0.005/-0.000	Ø 0.196	✓			
5.50	+/-0.030	5.501	✓			
0.125	+/-0.010	0.125	✓			
0.063	+/-0.010	0.063	✓			
R0.25	+/-0.030	R 0.250	✓			
4.27	+/-0.030	4.269	✓			
R0.30	+/-0.030	R 0.30	✓			

Measured by:	H.A. Fink	Audited by:	DIP	Prototype Approval:	N/A
Date:	08/07/07	Date:	08/07/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	JK

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20	TITLE BRACKET	SCALE 1:2	
A	04.04.20	NEW ISSUE	

RELEASED
04.04.09 *[Signature]***D3264-1 BRACKET****D3264-1:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T651)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010"
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH X 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
No 40255

